

Date: Thursday, 02/04/2009 2:25:21 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : OUTLET WELDMENT (206)
<b>Job Number</b> : 46836	
<b>Estimate Number</b> : 10473	
<b>P.O. Number</b> :	<b>Part Number</b> : D2414
<b>This Issue</b> : 02/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2414 REV. A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 35336	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 24/04/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.04.02</u>	
<b>Comment</b> : Est: C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2292	Heater Tube 4"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Tube 4"

Qty	Part Number	Description	Batch
1	D2292	4" Ring	<u>340621</u>

09.05.26 4

2.0	D2406	3" Heater Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

3" Heater Tube

Qty	Part Number	Description	Batch
1	D2406	3" Tubing	<u>327184=1</u>

341175=3

09.05.26 4

3.0	D2415	206 End Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

End Plate

Qty	Part Number	Description	Batch
1	D2415	End Plate	<u>326918</u>

09.05.26 4

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Weld D2414 Outlet Assembly as per Dwg D2414 and QSI 004.

09.05.26 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 02/04/2009 2:25:21 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET WELDMENT (206)

Job Number: 46836

Part Number: D2414

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC9 + QCS

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

QCS 8/09/05/27 (4)

QC9 → RE 09/05/27 (x4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

UMD 09/05/27 (x4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

RE 09/05/27 (4)

8.0

OUTSIDE SERV.15

OUTSIDE SERVICES - LF



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8891

Red Anodize D2414 as per Dwg D2414

Possible Supplier: Anodizing TNM Paint (red.)

Ensure Certificate of Conformity is attached

C 09/05/29

(4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

RE 9/5/5 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/06/08 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5T169

8/09/06/05 (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/09 (4)

MF 09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2414	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 OUTLET WELDMENT SCALE	

RELEASED  
7/6/09/10 BW

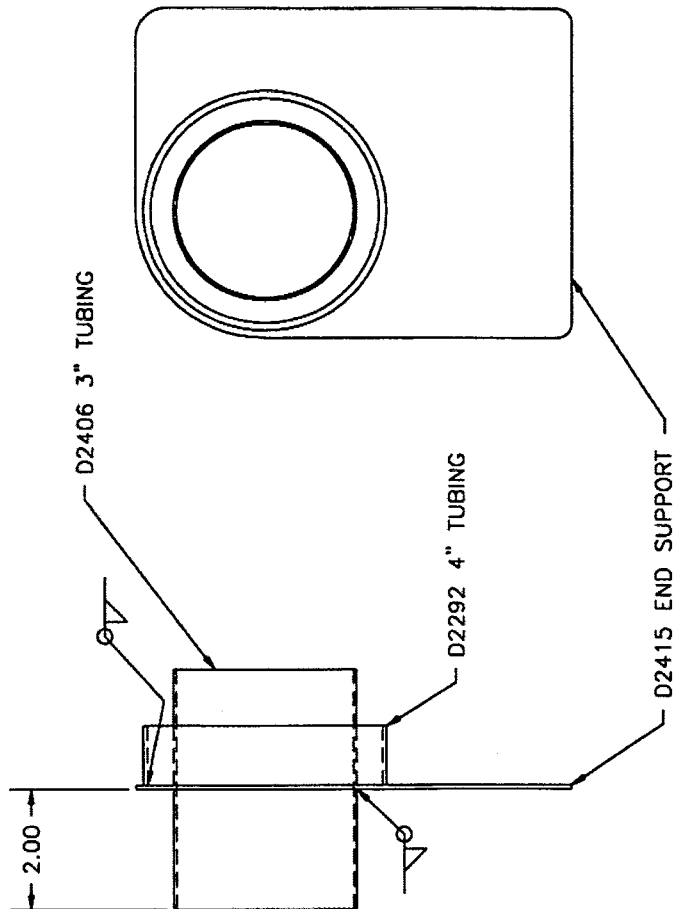
QTY	Part No.	Description
X	D2414	OUTLET WELDMENT ASSEMBLY
1	D2292	4" TUBING
1	D2406	3" TUBING
1	D2415	END PLATE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK CENTER  
NO. 410836



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2414	REV. A SHEET 2 OF 2
DATE Apr. 6, 1995		TITLE 206 OUTLET WELDMENT SCALE	

RELEASED  
96/09/10 BW



FINISH: ANODIZE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK CENTER  
NO. 46830

# TNM ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

PACKING

SLIP

75582

6/4/2009

CLIENT / CUSTOMER:

ART AEROSPACE LTD.

270 ABERDEEN STREET

AWKESBURY, ONTARIO

6A 1K7

NO. DE COMMANDE:

PURCHASE ORDER/

513952/8891

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	
1	20	20	D2091	B43591
2	4	4	D2414	B46836

PO 8891

PICKED UP BY / RECU: \_\_\_\_\_

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilités se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.



TNM

**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

75582

6/4/2009

CLIENT / CUSTOMER:

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE

PART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

NO. DE COMMANDE: 513952/8891  
PURCHASE ORDER/  
Conformance  
Nadcap  
Chemical Process  
Nondestructive Testing

ITEM	QUANTITY	QUANTITY	DESCRIPTION	REFERENCE	REMARKS
1	20	20	D2091	B43591	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
2	4	4	D2414	B46836	RED ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

509/66/08

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient

Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager